

Date: Friday, 12/12/2008 2:23:57 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GASKET
Job Number : 44054	
Estimate Number : 11159	
P.O. Number :	Part Number : D32563
This Issue : 12/12/2008 S.O. No. :	Drawing Number : D3256 REVC
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 43638	Material :
Written By :	Due Date : 10/01/2009 Qty: 6 Um: Each
Checked & Approved By : <u>JAD 08.12.15</u>	
Comment : Est B 04.12.06 Made in-house KJ/JLM	
Est Rev:C ecn 1052/water jet 07-11-05 DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D3245	Gasket
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Comment: Qty.: 1.0710 sf(s)/Unit Total : 6.4260 sf(s)

GASKET

Batch: 35607HB 8-12-16

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3256

Dwg Rev: CProg Rev: CHB 8-12-16

8

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINEHB 8-12-16

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

8 08/12/16 88

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: ST183

88 08/12/17 48

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 12/12/2008 2:23:57 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 44054

Part Number: D32563

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/17

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-12-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <u>W4054</u>
Description: Access Panel		Part Number: D3256-3
Inspection Dwg: D3256	Rev: C	Page 1 of 1

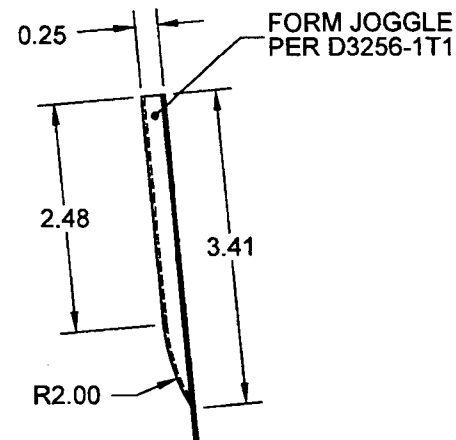
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

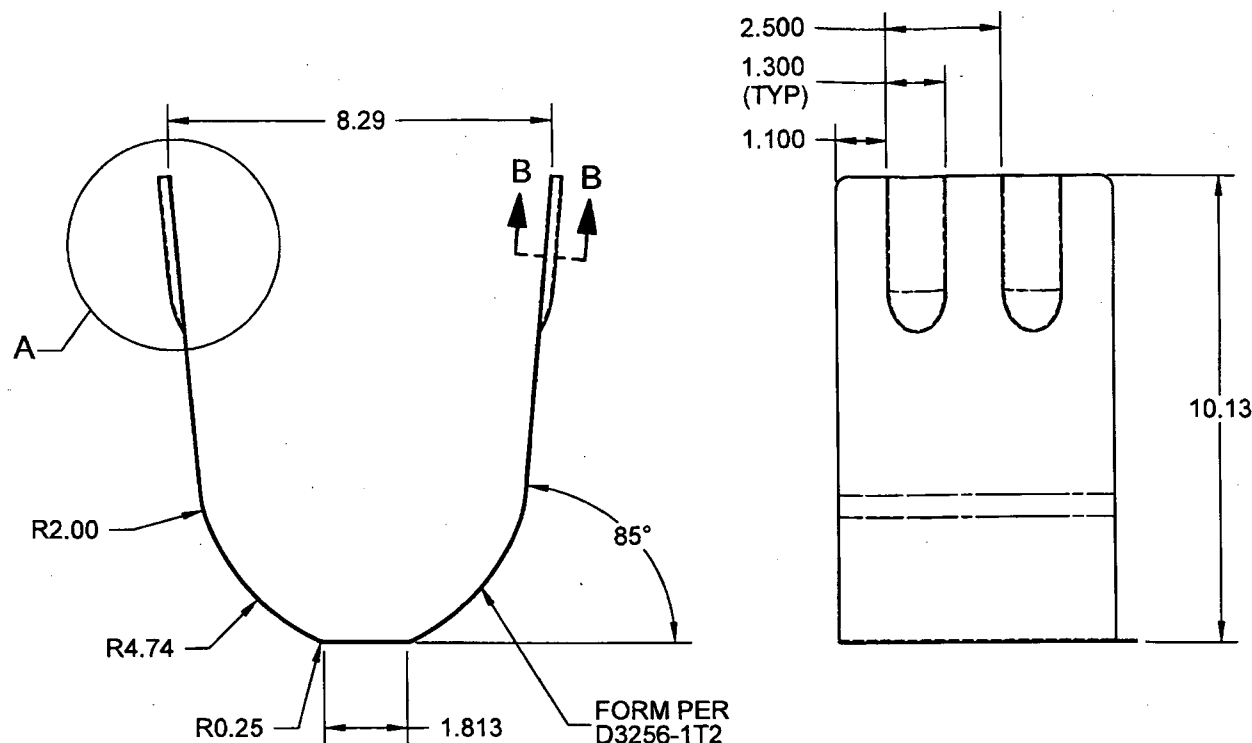
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
24.00	+/-0.030	24.00	✓			
6.10	+/-0.030	6.092	✓			
11.25	+/-0.030	11.254	✓			
10.55	+/-0.030	10.553	✓			
1.60	+/-0.030	1.589	✓			
1.50	+/-0.030	1.489	✓			
4.15	+/-0.030	4.155	✓			
1.30	+/-0.030	1.293	✓			
0.65	+/-0.030	.645	✓			
0.65	+/-0.030	.655	✓			
0.45	+/-0.030	.445	✓			

Measured by: <u>VB</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>8-12-16</u>	Date: <u>08/12/16</u>	Date:	N/A

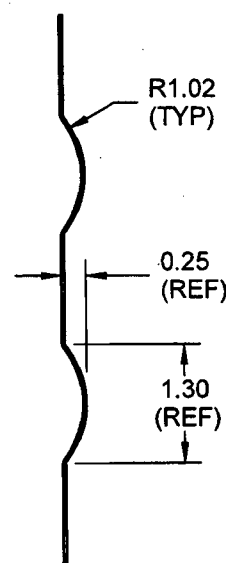
Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	<u>AS</u>



DETAIL A
SCALE 1:2

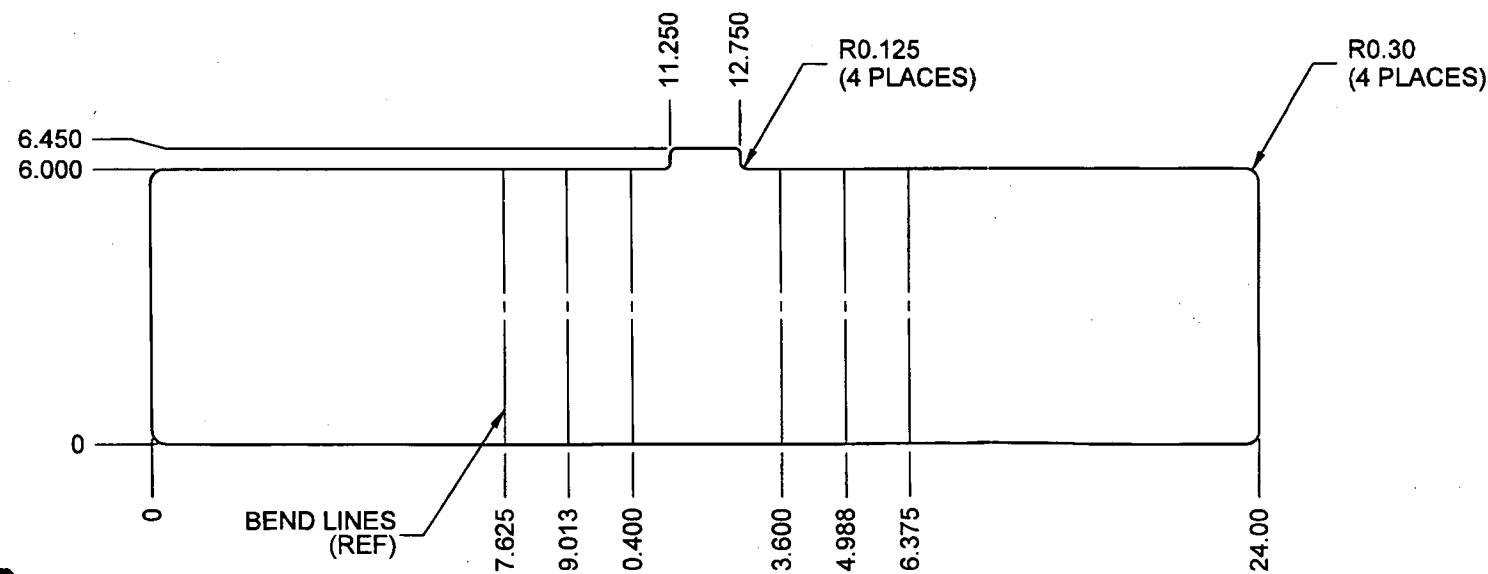


D3256-1 ACCESS PANEL
(MAKE FROM D3256-1F)



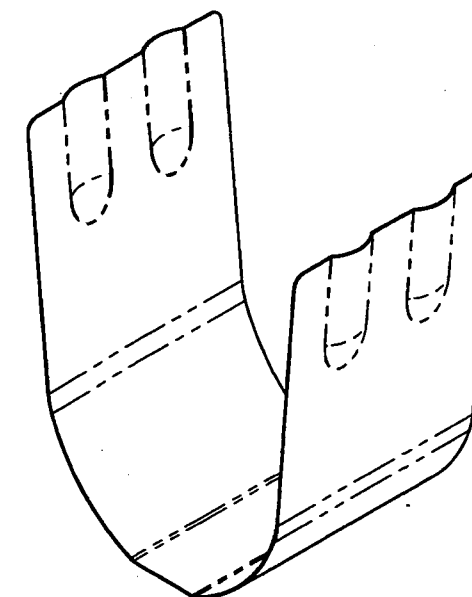
SECTION B-B
SCALE 1:2
(VIEW ROTATED)

RELEASED
07.10.23



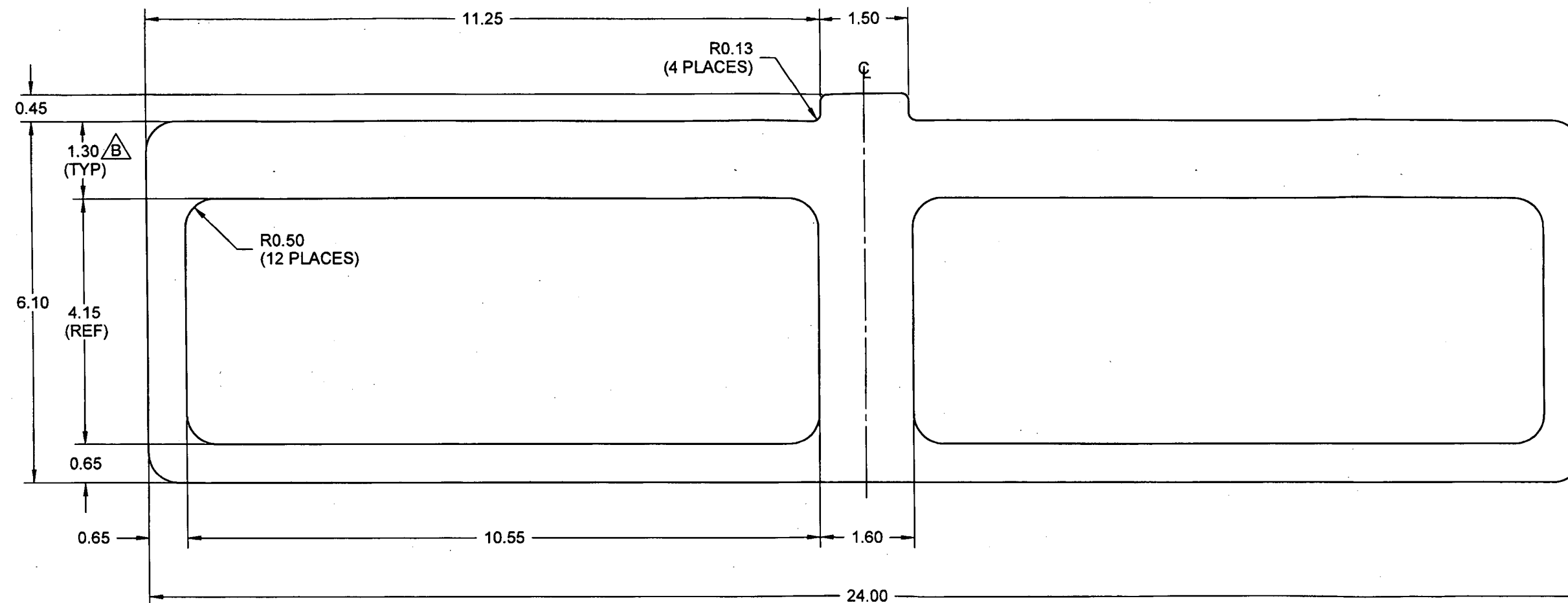
D3256-1F FLAT PATTERN 1

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3256-1" AND B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.37 lbs



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NO. 111054

C	D3256-041 ELIMINATED: REMOVED (QTY.22) 0.128 HOLES FROM D3256-1F AND D3256-3 GASKET. INSTRUCTIONS TO DRILL HOLES AND INSTALL D3256-3 GASKET ARE NOW PART OF THE INSTALLATION INSTRUCTIONS	MB	07.09.28
B	D3256-3 DIM 1.30 WAS 0.65	RF	05.06.27
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	B		
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	DS	D3256	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	ACCESS PANEL	1:4
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D3256-3 ACCESS PANEL

RELEASED
07-10-23

NOTES:

- 1) MATERIAL: DURABLE BLACK GASKET 0.035 THICK PER MIL-A-7021C OR MIL-A-17472B (CLASS 1 & 2) OR MIL-G-12803A (GRADE P-1161A)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

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NO. 44054

DESIGN	JH	DART AEROSPACE LTD	
DRAWN	JA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	DS	D3256	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	HL	ACCESS PANEL	1:2
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